

Work Order ID 112119

January-29-14 12:53:17 PM

112119

Page 1

Item ID: D412-742-013
Revision ID:
Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible
Start Date: 1/29/14 Start Qty: 1.00
Required Date: 2/12/14 Req'd Qty: 1.00
Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLS Date: 14-01-29
QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-742	E								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-742-013 CHG007								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
31
9-89

14-02-04

1

DAS
26
9-89

1K

14-1-31

DAS
31
9-89

14-04-9

1

B1100201

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D412-742-013**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible**Start Date:** 1/29/14 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 2/12/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____**Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____**SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

130

Packaging

Packaging

Memo

0.00

**DAS
06
9-89**

0.00

APR 19 2014

Packaging

Identify and pack for shipping as per PPP D412-742-013

Location: 073

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

14/4/9 18
14-04-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A05.10.13New Issue KJ/JLM
 IPP Rev:B 06-06-08 As per DSI9336 JLM
 07-12-03 ECN 1072 DD verified by:JLM
 IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC
 IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add
 AN4C7A DD 10.01.13 verified by:EC IPP Rev:G 11.11.01 as per
 DSI9517 REV.B DD verified by:EC IPP rev:H 12.01.12 PER IIN
 REV.E DD VERF: IPP Rev:I add AN4C7A DD 12.03.14
 verified by:EC

IPP RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A		Purchased		No		110	Each	95.0000	4	4			
AN4C47A Bolt DAS 31 9-89													
					<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					DAS 26 9-89
					FG		10						
					122491		10						
					ST359		10						
					112491		4						
					M126007		6						
					ST517a		75						
					M126293		75		4x				
D412-742-043		Manufactured		No		110	Each	0.0000	1	1			
D412-742-043 Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible DAS 31 9-89													
D2571		Manufactured		No		110	Each	19.0000	1	1			
D2571 Saddle, Fwd, Out DAS 31 9-89													
					<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					DAS 26 9-89
					ST441		19						
					104701		6						
					105995		1						
					109923		12						

DAS
26
9-89

DAS
06
9-89

DAS
26
9-89

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

D2572

Manufactured No

110

Each

23.0000

1 1

D2572

Saddle, Fwd, In

**

DAS

26

9-89

DAS

26

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST441

23

105572

1

106514

5

108485

5

109924

12

D2573

Manufactured No

110

Each

37.0000

1 1

D2573

Saddle, Aft, Out

**

DAS

26

9-89

DAS

26

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST442

25

105413

4

108126

4

108525

5

109763

12

ST453a

12

109925

12

D2574

Manufactured No

110

Each

33.0000

1 1

D2574

Saddle, Aft, In

**

DAS

26

9-89

DAS

26

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST442

33

106416

1

108523

10

109607

10

109926

12

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

D2876 Manufactured No

110 Each

41.0000

2 2

DAS
26
9-89

D2876

Saddle Spacer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST020

41

106074

14

108425

27

2x

D2877 Manufactured No

110 Each

41.0000

2 2

DAS
26
9-89

D2877

Saddle Spacer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST020

41

103013

2

106231

13

108487

26

2x

D3403-1 Manufactured No

110 Each

146.0000

8 8

DAS
26
9-89

D3403-1

Bushing

DAS
31
9-89

Location

Loc Qty

Loc Code

ST041

146

88782

146

8x

D3403-5 Manufactured No

110 Each

118.0000

8 8

DAS
26
9-89

D3403-5

Bushing

DAS
31
9-89

Location

Loc Qty

Loc Code

ST042

118

88784

118

8x

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Shop Packet Print

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Handling/Pre									
Material									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

D2747

Manufactured No

110 Each 219.0000 4 4

D2747

Set Screw

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST017

219

106173

60

110232

100

86827

58

99355

1

110 Each 100.0000 2 2

**

DAS
26
9-89

D3533-1

Manufactured No

D3533-1

Set Screw

DAS
31
9-89

Location

Loc Qty

Loc Code

ST054

100

102438

100

110 Each 421.0000 16 16

**

DAS
26
9-89

AN4C6A

Purchased No

AN4C6A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST355

407

m125709

407

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 5

Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

AN4C53A Purchased No

110 Each 51.0000 4 4

AN4C53A

BOLT

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST360

21

122193
~~M127204~~

3

18

ST518

30

M127061

30

110 Each 65.0000 4 4

AN4C52A Purchased No

AN4C52A

Bolt

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

5

122518

5

ST360

10

122518

4

M126293

6

ST518

50

M126007

50

110 Each 114.0000 8 8

AN6C12A Purchased No

AN6C12A

Bolt

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST339

56

M127290

56

ST505

58

M126105

8

M126180

50

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

110 Each

849.0000

32 32

**

DAS
26
9-89

D3672-3

Phenolic Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

111

84432

11

89273

100

FP001

79

107316

79

ST060

500

110251

500

ST061

159

93925

159

NAS1149C0432R

Purchased No

110 Each

5,250.000

32 32

**

DAS
26
9-89

NAS1149C0432R

WASHER

DAS
31
9-89

Location

Loc Qty

Loc Code

GA

1979

m125807

1979

ST292

68

119124

6

121255

7

122441

55

ST510a

3203

m126221

3203

D3672-9

Manufactured No

110 Each

358.0000

8 8

**

DAS
26
9-89

D3672-9

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST060

358

81763

8

94989

350

8X

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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0632R

Purchased

No

110

Each

148.0000

8 8

**

DAS
26
9-89

NAS1149C0632R

WASHER

DAS
31
9-89

Location

Loc Qty

Loc Code

ST292

148

121825

8

125654

140

D3672-11

Manufactured

No

110

Each

326.0000

8 8

**

DAS
26
9-89

D3672-11

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

77483

10

ST060

316

77483

8

91746

308

MS21043-4

Purchased

No

110

Each

540.0000

29 29

**

14-2-3

DAS
26
9-89

MS21043-4

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

43

125807

43

ST509

457

m127255

457

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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

DAS
26
9-89

D3403-3 Manufactured No

110 Each 185.0000 8 8

D3403-3
Bushing

DAS
31
9-89

Location

Loc Qty

Loc Code

ST041

185

88783

185

D3405-041 Manufactured No

110 Each 16.0000 1 1

D3405-041
Gh Lug

DAS
31
9-89

Location

Loc Qty

Loc Code

ST468

16

108437

12

109490

4

D3405-043 Manufactured No

110 Each 27.0000 1 1

D3405-043
Gh Lug

DAS
31
9-89

Location

Loc Qty

Loc Code

ST461

16

107261

16

ST468

11

105544

1

108792

10

DAS D
26
9-89

DAS D
26
9-89

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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

AN4C7A Purchased No

110 Each 165.0000 4 4

AN4C7A

BOLT

DAS
31
9-89

Location

Loc Qty

Loc Code

ST355

4

109147

4

ST513

61

125388

61

ST518

100

m127363

100

110 Each

30.0000

1 1

D3407-041

Manufactured No

D3407-041

Tow Ring

DAS
31
9-89

Location

Loc Qty

Loc Code

ST444

3

107840

3

ST463

27

107954

3

109405

8

110069

8

110684

8

110 Each

63.0000

2 2

D3417-3

Manufactured No

D3417-3

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

7

33519

7

ST042

56

106077

14

109129

40

93758

2

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Picklist Print

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Page 10

Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

176.0000

1

1

D3456-1

Washer

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST046

169

~~103539~~

1

103787

25

107629

17

109751

1

111514

25

111782

100

/X

AN3C37A

Purchased No

110

Each

127.0000

1

1

AN3C37A

BOLT

DAS
26
9-89

Location

Loc Qty

Loc Code

ST324

4

M121068

4

ST353

123

M126345

48

M127823

75

/X

AN3C40A

Purchased No

110

Each

28.0000

1

1

AN3C40A

Bolt

14-2-3

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

5

11442

5

ST353

23

114442

1

M125958

1

M126176

21

/X

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Page 11

Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

AN3C41A Purchased No

110 Each 71.0000 1 1

DAS
26
9-89

AN3C41A
Bolt

DAS
31
9-89

Location Loc Qty Loc Code

FG	9	
103324	4	
122843	5	
ST353	62	
m127300	12	1X
m127544	25	
m127823	25	

AN3C42A Purchased No

110 Each 32.0000 1 1

DAS
26
9-89

AN3C42A
Bolt

DAS
31
9-89

Location Loc Qty Loc Code

FG	5	
121103	5	
ST353	27	
m126293	2	
m127300	25	1X

AN3C43A Purchased No

110 Each 93.0000 4 4

DAS
26
9-89

AN3C43A
Bolt

DAS
31
9-89

Location Loc Qty Loc Code

FG	10	
120465	10	
ST354	83	
120465	4	
M126007	4	
M126621	25	4x
M127201	25	
M127721	25	

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Work Order ID: 112119

112119

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/29/14

Required Date: 2/12/14

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Purchased No

110 Each

112.0000

5 5

AN3C46A

Bolt

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	10	
122843	10	
ST353	95	
M127578	20	
M127823	75	
ST354	7	
M127281	7	

NAS1149C0332R Purchased No

110 Each

10,244.00

26 26

NAS1149C0332R

WASHER

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

GA	1197	
125654	1197	
st510	9047	
m126319	1147	
m127306	2500	
m127410	3000	
m127831	2400	

MS21043-3 Purchased No

110 Each

829.0000

13 13

MS21043-3

Nut

**

DAS
26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
ST315	749	
124555	92	
m126741	657	

14-1-31

13x

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5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty 013	Qty 043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	X	X	*D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*10	*AN3C6A	*BOLT
4		*4	*AN3C7A	*BOLT
5		*38	*AN960C10L	*WASHER
21		*1	*D4095-041	*WEARSHOE (REPLACES D3564-1)
22		*1	*D4095-043	*WEARSHOE (REPLACES D3564-3)
23		*1	*D4095-045	*WEARSHOE (REPLACES D3564-5)
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24		**1	**D4095-051	**WEARSHOE (REPLACES D3564-13)
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25		**1	*D4095-049	**WEARPAD (REPLACES D3537-1)
26		**1	*D4095-047	**WEARPAD (REPLACES D3537-7)
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**8	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 20)

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D412-742

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(CONTINUED FROM PAGE 19)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46A	8		D3403-1	BUSHING
46B	8		D3403-5	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49A	4		AN4C52A	BOLT
49B	4		AN4C53A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	8		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		AN4C7A	BOLT
56	2		D3591-1	BUSHING
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C47A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E
Date: 11.10.19

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. E
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 4

REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

PURPOSE

For D412-742-011/-013 Float Skidtube Installations, qty(4) AN4C53A bolts may be replaced with qty(4) AN4C52A bolts. Kits may be supplied from Dart with either AN4C52A or AN4C53A bolts.

Note that it is acceptable to use longer or shorter AN4C bolts than those specified, as long as there is a minimum of 1.5 threads in safety.

CHANGE

The parts lists of Installation Instructions IIN-D412-742 Rev. E and Instructions for Continued Airworthiness ICA-D412-742 Rev. 4 is amended as follows:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List (IIN-D412-742)

32.18 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List (ICA-D412-742)

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION

IS:

49B	4			AN4C53A OR AN4C52A	BOLT
-----	---	--	--	-----------------------	------

WAS:

49B	4			AN4C53A	BOLT
-----	---	--	--	---------	------

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List (IIN-D412-742)

32.19 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List (ICA-D412-742)

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION

IS:

49B	4		AN4C53A OR AN4C52A	BOLT
-----	---	--	-----------------------	------

WAS:

49B	4		AN4C53A	BOLT
-----	---	--	---------	------

A	NEW ISSUE	CP	12.02.28
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC KENT, WA	
DRAWN			
CHECKED		DRAWING NO. REV. A DSI 9600 SHEET 1 OF 1	
MFG. APPR.			
APPROVED		TITLE SCALE BOLT SUBSTITUTION NTS	
DE APPR.			
DATE	12.02.28	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order ID 112119

January-29-14 12:53:17 PM

112119

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Item ID: D412-742-013
 Revision ID:
 Item Name: Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible
 Start Date: 1/29/14 Start Qty: 1.00
 Required Date: 2/12/14 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 14-01-29 Tooling:
 QC: Date: SPC (Y/N):

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-742	E								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-742-013								
	CHG007								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-31

IK 14-1-31 DAS 26 9-89